



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

C2-3-11
Job Sheet 184714



Part No: C2-3-11

Job Qty: 10 pcs

Part Name: Actuator



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/16/18

Job Tracking No:

Due Date: 11/9/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG C2-3-11 Rev 15 IPP Rev A 18.04.06 new issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs		
120	SL-154 - 1	10 pcs	11/9/18	11/9/18	0.00	10.00	SL-154 - 1	<i>19/04/23</i>
130	QC 2	10 pcs	11/9/18	11/9/18	0.00	0.00	QC 2 - 1	
							QC 2 - 12	
							QC 2 - 14	
							QC 2 - 17	
							QC 2 - 19	
							QC 2 - 2	
							QC 2 - 20	
							QC 2 - 22	
							QC 2 - 23	
							QC 2 - 25	
							QC 2 - 32	
							QC 2 - 33	<i>19/04/23</i>
							QC 2 - 35	
							QC 2 - 38	
							QC 2 - 39	
							QC 2 - 4	
							QC 2 - 40	
							QC 2 - 44	
							QC 2 - 45	
							QC 2 - 48	
							QC 2 - 49	
							QC 2 - 50	
							QC 2 - 51	
							QC 2 - 52	
							QC 2 - 54	
							QC 2 - 56	
							QC 2 - 57	
							QC 2 - 62	
							QC 2 - 63	
							QC 2 - 8	



Container No: S174393



Part: C2-3-11

Job No: 184714

Serial No/Batch: S174393

Revision: 15

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 04/23/19

140	HAAS 4 Axis - B4B	10 pcs	11/9/18	1.50	5.00	HAAS - 1 - B4B	DAS 52 9-89 19/04/27
						HAAS - 2 - B4B	
						HAAS - 3 - B4B	
						HAAS - 4 - B4B	
150	QC 2	10 pcs	11/9/18	0.00	0.00	QC 2 - 1	DAS 52 9-89 19/04/27
						QC 2 - 12	
						QC 2 - 14	
						QC 2 - 17	
						QC 2 - 19	
						QC 2 - 2	
						QC 2 - 20	
						QC 2 - 22	
						QC 2 - 23	
						QC 2 - 25	
						QC 2 - 32	
						QC 2 - 33	
						QC 2 - 35	
						QC 2 - 38	
						QC 2 - 39	
						QC 2 - 4	
						QC 2 - 40	
						QC 2 - 44	
						QC 2 - 45	
						QC 2 - 48	
						QC 2 - 49	
						QC 2 - 50	
						QC 2 - 51	
						QC 2 - 52	
						QC 2 - 54	
						QC 2 - 56	
						QC 2 - 57	
						QC 2 - 62	
						QC 2 - 63	
						QC 2 - 8	
160	QC 8	10 pcs	11/9/18	0.00	0.00	QC 8 - 12	DAS 52 9-89 19-08-01
						QC 8 - 14	
						QC 8 - 17	
						QC 8 - 20	
						QC 8 - 25	
						QC 8 - 3	
						QC 8 - 32	
						QC 8 - 33	
						QC 8 - 35	
						QC 8 - 38	
						QC 8 - 39	
						QC 8 - 4	
						QC 8 - 44	
						QC 8 - 45	
						QC 8 - 49	
						QC 8 - 58	
						QC 8 - 8	
						QC 8 - 9	
						QC 8 - 68	
						QC 8 - 67	
170	Packaging 3-1 - Stock - B4B	10 pcs	11/9/18	0.00	0.00	Packaging 3 - 1 - B4B	
						Packaging 3 - 2 - B4B	
						Packaging 3 - 3 - B4B	
						Packaging 3 - 4 - B4B	

				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	DAS
				Packaging 3 - 7 - B4B	28
				Packaging 3 - 8 - B4B	9-89
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	DAS
180 QC 21 - SA	10 pcs	11/9/18	0.00 0.00	QC 21 - SA - 21	21
				QC 21 - SA - 70	9-89
Part Op 120 - SL-154 (MORI SL-154 LATHE) 1-Machine as per folio FC017 FOLIO REV: <u>AA</u> DWG REV: Descriptions: <u>15</u> 2-Generate serial# and see PEC for programming 3-Deburr 130 - QC2 Machining-5 (QC2- Inspect parts off machine FAI/FAIB) 140 - HAAS 1 (HAAS CNC vertical machine #1) 1-Machine as per folio FC017 FOLIO REV: <u>15</u> DWG REV: <u>15</u> 2- Generate serial # and see PEC for programming. 3-Deburr 150 - QC2 Machining-5 (QC2- Inspect parts off machine FAI/FAIB) 160 - QC8 Machining-5 (QC8- Inspect parts - second check) 170 - Packaging3-2 (Identify as per dwg & Stock Location: _____) 180 - QC21 (QC21- Final Inspection - Work Order Release)					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
M17-4-H1150-R1.500	17-4 SS Round Bar 1.500"	1.5000 ft (.15 ea)	120-SL-154 - 1	<u>5172607</u>	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
120-SL-154 - 1	M17-4-H1150-R1.500	2	21	0	
Part Specifications					
Specifications could not be found.					



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

C2-3-11
Job Sheet 184714



Part No: C2-3-11

Job Qty: 10 pcs

Part Name: Actuator



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/16/18

Job Tracking No:

Due Date: 11/9/18

Created By: Marie Lajeunesse

Type: ~~SOLD~~ *gjh*

Description:

Note: DWG C2-3-11 Rev 15 IPP Rev A 18.04.06 new issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea		11/9/18	0.00	0.00	Start Up Machining-4		
120	Mori Seiki	10 pcs		11/9/18	0.00	10.00	MORI SL-154		
130	QC	10 pcs		11/9/18	0.00	0.00	QC2 Machining-5		
140	CNC Vertical Machining	10 pcs		11/9/18	1.50	5.00	HAAS 1		
150	QC	10 pcs		11/9/18	0.00	0.00	QC2 Machining-5		
160	QC	10 pcs		11/9/18	0.00	0.00	QC8 Machining-5		
170	Packaging	10 pcs		11/9/18	0.00	0.00	Packaging3-2		
180	QC	10 pcs		11/9/18	0.00	0.00	QC21		

Part Op 120 - 1-Machine as per folio FC017 FOLIO REV: _____ DWG REV: _____ 2-Generate serial# and see Descriptions: PEC for programming 3-Deburr

140 - 1-Machine as per folio FC017 FOLIO REV: _____ DWG REV: _____ 2- Generate serial # and see PEC for programming. 3-Deburr

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M17-4-H1150-R1.500	17-4 SS Round Bar 1.500"	1.5000 ft (.15 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M17-4-H1150-R1.500	2	1	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

DART AEROSPACE LTD		Work Order:	184719
Description: Actuator		Part Number:	C2-3-11
Inspection Dwg: C2-3-11		Rev: 15	Page 1 of 1

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.597	+/-0.005	0,596	✓		MIP-04	vern
0.27	+/-0.01	0,270	✓			
R0.05	+/-0.01	0,050	✓			
0.465	+/-0.005	0,465	✓			
Ø0.1285	+0.005/-0.000	0,130	✓			
0.244	+/-0.005					
Ø0.375	+/-0.005	0,377	✓			
0.65	+/-0.01	0,650	✓			
Ø0.562	+0.000/-0.002	0,562	✓			
0.02 x 45°	+/-0.01 x +/-0.5°	0,020 x 45°	✓			
0.617	+0.000/-0.003	0,614	✓			
0.651	+/-0.005	0,651	✓			
Ø0.696	+/-0.005	0,695	✓			
0.02 x 45°	+/-0.01 x +/-0.5°	0,020 x 45°	✓			
Ø0.562	+0.000/-0.002	0,562	✓			
Ø0.308	+0.000/-0.002	0,308	✓			
0.02 x 45°	+/-0.01 x +/-0.5°	0,020 x 45°	✓			
Ø0.199	+/-0.005	0,199	✓			
0.09	+/-0.01	0,090	✓			
R0.02	+/-0.01	0,015	✓			
0.01 x 45°	+/-0.01 x +/-0.5°	0,010 x 45°	✓			
1.596	+/-0.005	1,596	✓			
0.923	+/-0.005	0,923	✓			
0.748	+/-0.005	0,748	✓			
0.470	+/-0.005	0,470	✓			
0.136	+/-0.005	0,136	✓			
0.345	+/-0.005	0,344	✓			
0.188	+/-0.005	0,188	✓			
0.328	+/-0.005	0,328	✓			
0.976	+/-0.005	0,978	✓			
0.361	+/-0.005	0,362	✓			
0.742	+/-0.005	0,743	✓			
0.525	+/-0.005	0,522	✓			
0.465	+/-0.005	0,464	✓			
0.346	+/-0.005	0,347	✓			
0.048	+/-0.005	0,048	✓			
0.04 x 45°	+/-0.01 x +/-0.5°	0,040 x 45°	✓			

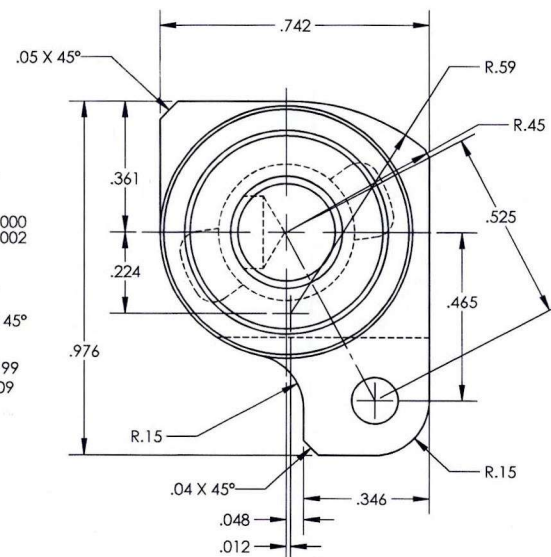
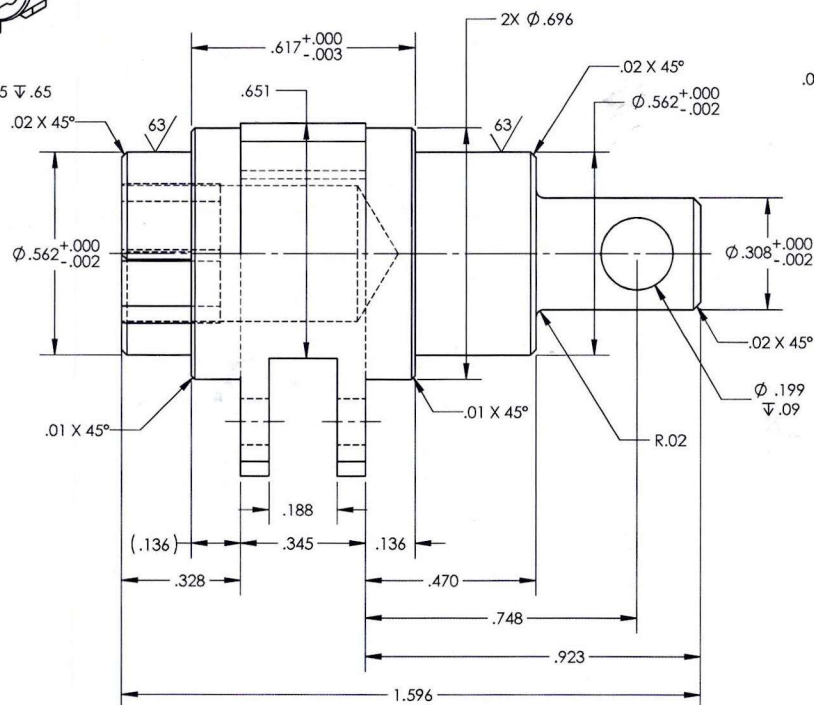
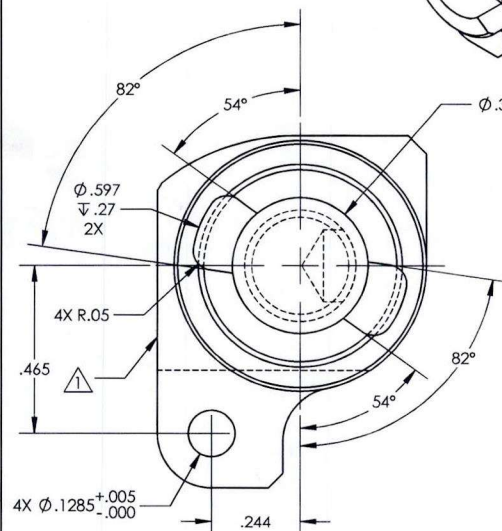
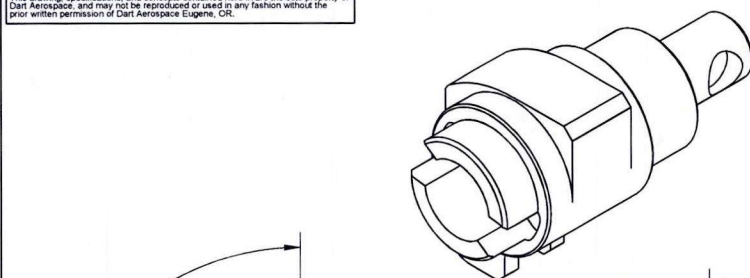
Measured by:	<i>[Signature]</i>	Checked by:	<i>[Signature]</i>	QC Inspector:	
Date:	19/04/23	Date:	19-05-01	Date:	

Engineering Approval: (If necessary)		Date:	
--	--	--------------	--

Rev	Date	Change	Revised by	Approved
A	18.07.04	New Issue	KJ	<i>[Signature]</i>

This drawing, specifications, and concepts contained here in are the sole property of Dart Aerospace, and may not be reproduced or used in any fashion without the prior written permission of Dart Aerospace Eugene, OR.

REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
13		CHANGED TOLERANCE ON Ø.1285 HOLE FROM $\pm .003$ TO $\pm .005$ / $-.000$.	8/27/2012	JAG
14	14-0104	CH'D TITLE BLOCK WAS RED BARN IS DART. ADDED MACHINE ENGRAVE NOTE. CH'D DIMENSION TOLERANCES ON NON-CRITICAL DIMENSIONS.	8/6/2014	DPD RW
15	17-0062	UPDATED TO NEW STANDARDS. CH'D MAT'L WAS SS 17-4PH IS SS 17-4PH H1025-H1150. REMOVED	3/17/2017	SM JAG



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 184714 MLW
18-10-16

NOTE:

1 MACHINE ENGRAVE BATCH NUMBER.

DART AEROSPACE	
TITLE ACTUATOR	
DWG NO. C2-3-11	REV 15
MAT'L SS 17-4PH H1025-H1150 FINISH SPEC DRAWN BY: CANAM CHECKED: DD 03/17/2017 OP'S APPR: AA 06/15/2017 QA APPR: JL 06/28/2017 APPROVED: JAG 07/06/2017 SCALE 3:1 DATE 11/12/2001 SHEET 1 OF 1	

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS
			C2-3-11	1	ACTUATOR	SS 17-4PH H1025-H1150	